



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3204-041
Job Sheet 162487



Part No: D3204-041

Job Qty: 4 ea

Part Name: Release Pedal Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 11/15/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D3204-041 Release Pedal Assembly	DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM		0.000	
D3204-1 Tube	DWG REV A1 IPP: B 04.06.09 Change Step 6; remove Steps 7 & 8 KJ/RF		0.000	
D3204-11 Plate	DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM IPP Rev:D Now on Waterjet 08-01-08 JLM Verified By:EC		0.000	
D3204-13 Gusset	DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM		0.000	
D3204-3 Arm	DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM		0.000	
D3204-5 Arm	DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM		0.000	
D3204-7 Bushing	DWG REV A1 IPP: B 04.06.09 Change Step 6; remove Steps 7 & 8 KJ/RF		0.000	
D3204-9 Pedal	DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM		0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	4 Ea	11/14/17	0.00	0.00	Start up container	
120	QC	4 pcs	11/14/17	0.00	0.00	QC5	
130	HandFinish	4 pcs	11/14/17	0.00	0.38	HandFinish1	
140	Powdercoat	4 pcs	11/14/17	0.00	0.30	Powdercoat3	
150	QC	4 pcs	11/14/17	0.00	0.00	QC3	
160	Small Fab	4 pcs	11/15/17	0.00	0.27	Small Fab	
170	QC	4 pcs	11/15/17	0.00	0.00	QC5	
180	Packaging	4 pcs	11/15/17	0.00	0.00	Packaging3	
190	QC21-SA	4 Ea	11/15/17	0.00	0.00	QC21	

Part Op 140 - ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE:
Descriptions: 180 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation
D3204-1	Tube	4 Ea (1 ea)	90-Start up Operator
D3204-11	Plate	4 Ea (1 ea)	90-Start up Operator
D3204-13	Gusset	8 Ea (2 ea)	90-Start up Operator

Status: Stock

Part: **D3204-041 B162487**

Created: 9/30/17 12:09 PM DART.MICHAUD-
FEBRILLE.VICTORIA



Serial No: **S000087**

Printed By: Goldston, Justin 10/2/17 10:45 AM

D3204-3	Arm	4 Ea (1 ea)	90-Start up Operation
D3204-5	Arm	4 Ea (1 ea)	90-Start up Operation
D3204-9	Pedal	4 Ea (1 ea)	90-Start up Operation
D3204-7	Bushing	8 Ea (2 ea)	160-Small Fab

Job Allocations						
Operation	Component Part	Required	Inventory	Allocated	Std Qty	
90-Start up Operation	D3204-1	4	0	0	0	
	D3204-11	4	0	0	0	
	D3204-13	8	0	0	0	
	D3204-3	4	0	0	0	
	D3204-5	4	0	0	0	
	D3204-9	4	0	0	0	
	D3204-7	8	0	0	0	
	160-Small Fab					

Part Specifications

Specifications could not be found.

Work Order Summary

Thursday, September 28, 2017 11:22:19 AM

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Criteria : Work Order ID: 162487 Item ID: D3204-041 Product Family LARGE FAB
 Work Order Start Dates 6/14/2017 to 6/14/2017 11:59:59 PM Work Order Required Dates 6/23/2017 to 6/23/2017 11:59:59 PM
 All References
 Work Order Status Released

Work Order ID 162487 Required Qty 4.0000 Status Code Released
 Item ID D3204-041 Accepted Qty 0.0000 Scrap Qty 0.0000
 Item Name Release Pedal Assembly
 Current Acct Value \$429.964

Start Date 6/14/2017 Required Date 6/23/2017 Completed Date

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$39.873	\$0.000	\$7.828	\$7.828	100.00%
Labor	\$715.957	\$0.000	\$131.662	\$131.662	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$1,614.823	\$0.000	\$290.475	\$290.475	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$2,370.652	\$0.000	\$429.964	\$429.964	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
D3204-1 Tube	4.0000		9/26/2017	5.0000	\$60.646
D3204-11 Plate	4.0000		9/26/2017	5.0000	\$76.560
D3204-13 Gusset	8.0000		9/26/2017	10.0000	\$35.828
D3204-3 Arm	4.0000		9/26/2017	5.0000	\$251.071
D3204-5 Arm	4.0000		9/26/2017	5.0000	\$136.745
D3204-9 Pedal	4.0000		9/26/2017	4.0000	\$301.414
Total Matl Amts:					\$862.263

Work Center Large Fab

Employee ID	Rout Seq ID	Labor Date	Setup Hours	Actual Setup Hours	Labor Hours	Actual Labor Hours	Nbr of WOs	Setup Amount	Labor Amount	Fix Burd Amount	Var Burd Amount	Total Amounts
cris01		6/27/2017										
100			0.00	0.00	4.07	4.07	1.00	\$0.000	\$87.428	\$177.458	\$0.000	\$264.885

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Work Order Summary

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100		0.00	0.00	2.61	2.61	1.00	\$0.000	\$56.162	\$113.996	\$0.000	\$170.159
	6/28/2017										
100		0.00	0.00	2.89	2.89	1.00	\$0.000	\$62.195	\$126.242	\$0.000	\$188.437
100		0.00	0.00	0.66	0.66	1.00	\$0.000	\$14.227	\$28.877	\$0.000	\$43.103
	6/29/2017										
100		0.00	0.00	3.49	3.49	1.00	\$0.000	\$74.958	\$152.147	\$0.000	\$227.104
	7/3/2017										
100		0.00	0.00	5.12	5.12	1.00	\$0.000	\$110.039	\$223.354	\$0.000	\$333.393
100		0.00	0.00	1.82	1.82	1.00	\$0.000	\$39.143	\$79.451	\$0.000	\$118.594
	7/4/2017										
100		0.00	0.00	0.61	0.61	1.00	\$0.000	\$13.008	\$26.402	\$0.000	\$39.410
	7/5/2017										
100		0.00	0.00	0.80	0.80	1.00	\$0.000	\$17.183	\$34.877	\$0.000	\$52.060
	7/12/2017										
100		0.00	0.00	1.08	1.08	1.00	\$0.000	\$23.287	\$47.267	\$0.000	\$70.553
	9/26/2017										
100		0.00	0.00	0.01	0.01	1.00	\$0.000	\$0.228	\$0.463	\$0.000	\$0.691
	Total:	0.00	0.00	23.16	23.16	11.00	\$0.000	\$497.856	\$1,010.532	\$0.000	\$1,508.389

Work Order ID 162487

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162487

SCRAP

Page 1

Item ID: D3204-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Release Pedal Assembly
 Start Date: 6/14/2017 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 6/23/2017 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: *AS* Date: 20170607 Tooling: _____ Date: _____ Run Start *NR1*
 QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								

100

100

Large Fab

Large Fab

Large Fab

Memo

- 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding.
- 2- Place parts D3204-1,3,5,13 in jig number DT10295 for tacking parts together.
- 3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods...
- 4- Inside measurement should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal.
- 5- Fill #30 hole when parts are cooled to room temperature quickly at around 150 amps...

0.00

3.12

(4)

DK
17109/26

P.T.O.

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☒</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☒	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☒	Composite ☐	Supplier ☐																							
Date : <u>17-08-27</u>		Step #: <u>100</u>		QTY Effective : <u>4</u>		MRB (QSI042) Approval DAS 9 9-89 <u>17-08-27</u>																			
Description Work Order Deviation				Disposition																					
Pin holes found at end of part cause by "blow out" during welding 2x. process				Scrap & destroy no replace																					
				Completed By																					
				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>17-08-28</u>																					
				QC / QA Coordinator Approval DAS 9 9-89 <u>17-09-28</u>																					
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	☒ Manufacturing Process																								
Misidentified ☐	Past Due ☐	OTHER : <u>Pin holes.</u>																							

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FINISH TIME: _____

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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162487

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N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

Start Date: 6/14/2017 **Start Qty:** 4.00

Required Date: 6/23/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.04

Quality Control

160

0.00

160

Small Fab

Small Fab

Memo

0.26

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.08

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

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Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

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Work Order ID: 162487

162487

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 6/14/2017

Required Date: 6/23/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1 *D3204-1* Tube		Manufactured	No			100	Each	30.0000	1	4			
									**			DYC 17/09/26	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002			30					
					160395			30					
D3204-11 *D3204-11* Plate		Manufactured	No			100	Each	5.0000	1	4			
									**			DYC 17/09/26	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002			5					
					156241			5					
D3204-13 *D3204-13* Gusset		Manufactured	No			100	Each	8.0000	2	8			
									**			DYC 17/09/26	
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					WA002			8					
					153974			3					
					161671			5					
					162374								

Picklist Print

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Work Order ID: 162487

162487

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 6/14/2017

Required Date: 6/23/2017

Start Qty: 4.00

Required Qty: 4.00

D3204-3 Manufactured No

100 Each 5.0000 1 4

D3204-3

Arm

**

DYC 17/09/26

Location

Loc Qty

Loc Code

WA001

4

161002

4

WA002

1

150617

1

D3204-5 Manufactured No

100 Each 2.0000 1 4

D3204-5

Arm

**

DYC 17/09/26

Location

Loc Qty

Loc Code

WA001

2

153752

2

D3204-7 Manufactured No

160 Each 13.0000 2 8

D3204-7

Bushing

**

Location

Loc Qty

Loc Code

GA

13

147440

1

156248

12

D3204-9 Manufactured No

100 Each 2.0000 1 4

D3204-9

Pedal

**

DYC 17/09/26

Location

Loc Qty

Loc Code

WA001

2

153721

2

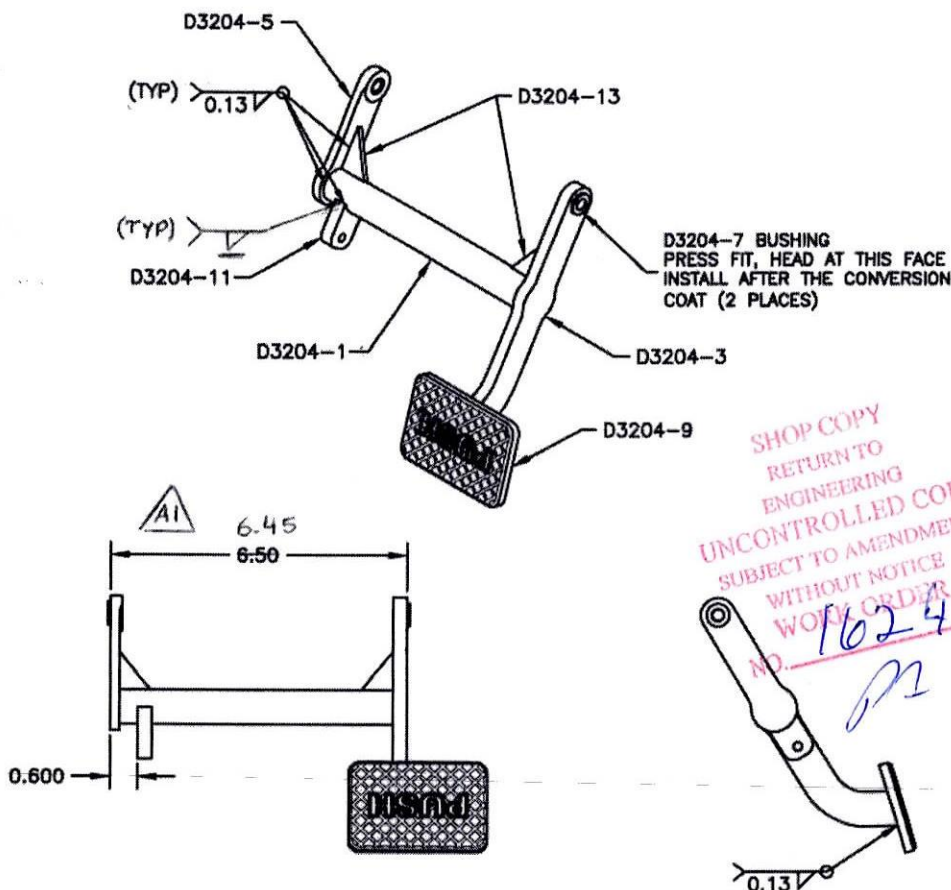
161673

2x

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

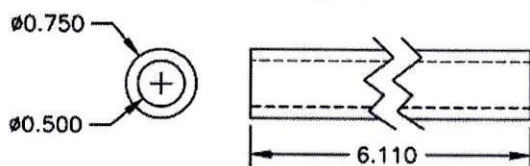
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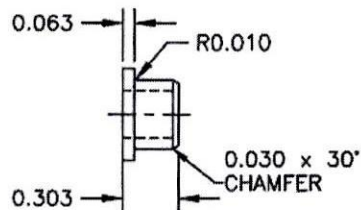


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

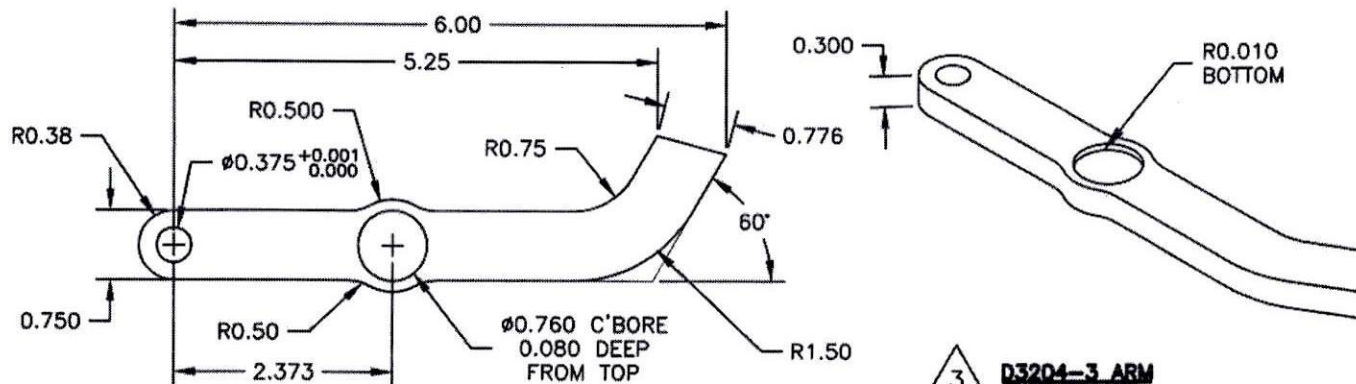
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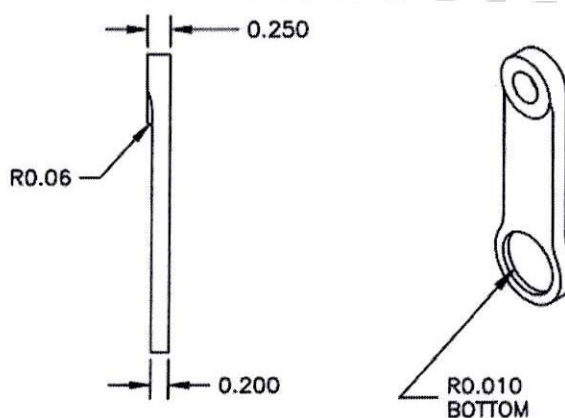
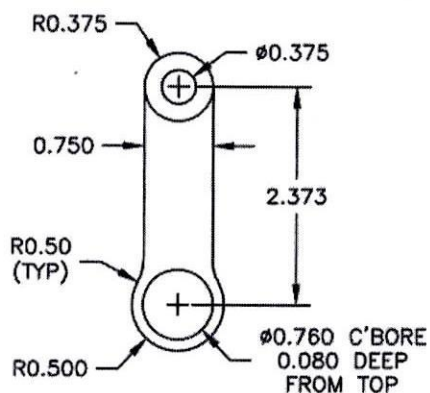
2 D3204-1 TUBE
SCALE 1:2



4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2

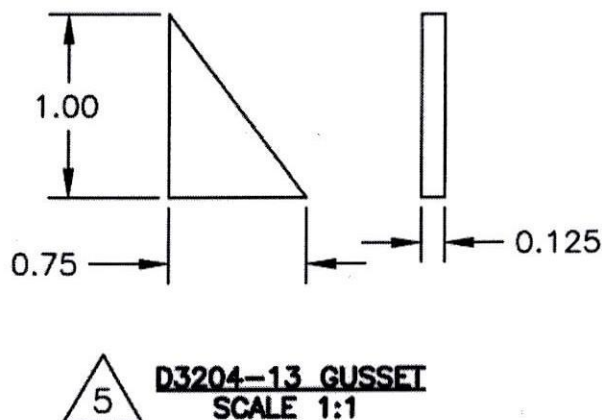
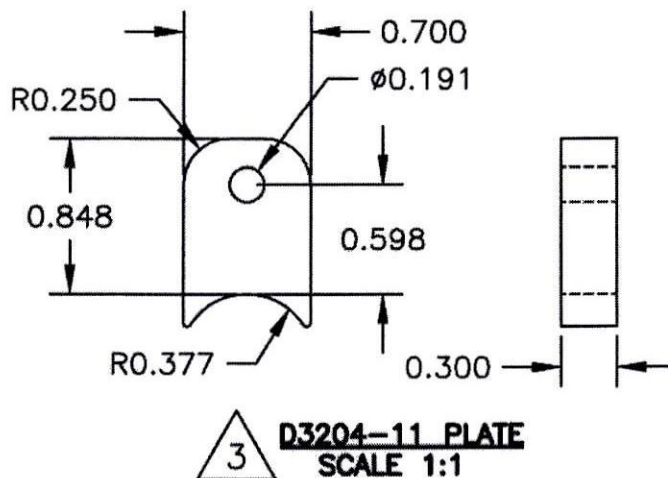
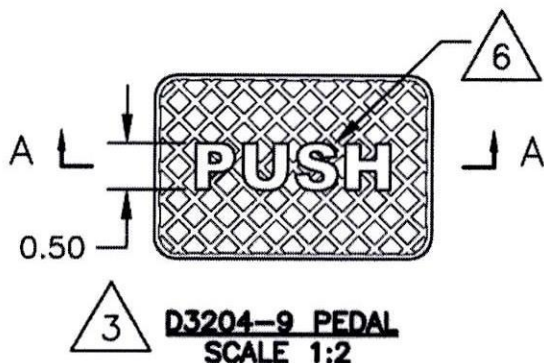
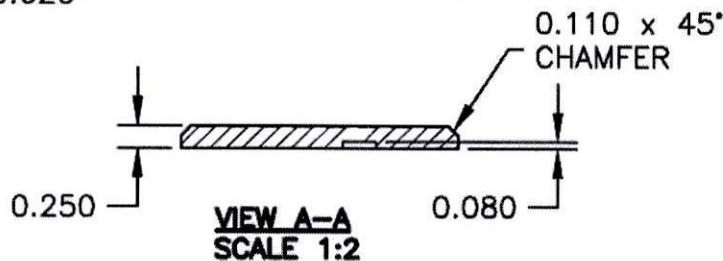
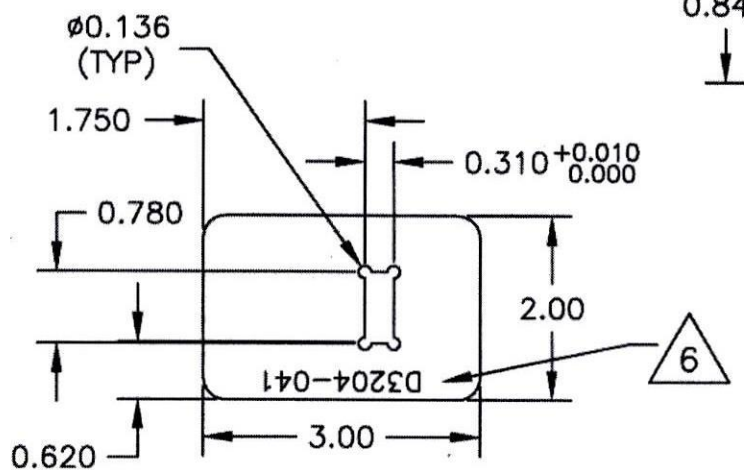
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